

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021947**Date Inspected:** 11-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13AW

PCMK: SEG3013B-252,253

Welder: 066421

WPS-B-T-2233-ESAB

PCMK: SEG3013M-017, 018

Welder: 067829

WPS-B-T-2233-ESAB

PCMK: SEG3013M-040

Welder: 067876

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WPS-B-T-2233-ESAB

PCMK: SEG3013D-146

Welder: 203871

WPS-B-T-2233-ESAB

PCMK: SEG3013M-053

Welder: 066421

WPS-B-T-2233-ESAB

Components: 14W

PCMK: SEG3020AJ-382,383

Welder: 204730

WPS-B-T-2132-ESAB

PCMK: SEG3020AJ-028, 029

Welder: 067949

WPS-B-T-2233-ESAB

PCMK: SEG3020AJ-105, 106

Welder: 045175

WPS-B-T-2233-ESAB

Components: Deck Panel

PCMK: SA7531-001,002

Welder: 048433

Report: B-WR20390

WPS-345-FCAW-2G (2F)-ESAB-repair

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: 13AW

PCMK: SEG3013D-231

Welder: 066038

WPS-B-P-2213-B-U2-FCM-1

PCMK: SEG3013AH-001

Welder: 066261

WPS-B-P-2212-TC-U4b-FCM-1

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PCMK: DP3122-023,024
Welder: 045196
WPS-B-P-2213-TC-U4b-FCM-1

Components: 14W
PCMK: SEG3020B-113
Welder: 045246
Report: B-WR20379
WPS-345-SMAW-3G (3F)-FCM-repair-1

PCMK: SEG3020B-114
Welder: 051348
Report: B-WR20379
WPS-345-SMAW-3G (3F)-FCM-repair-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

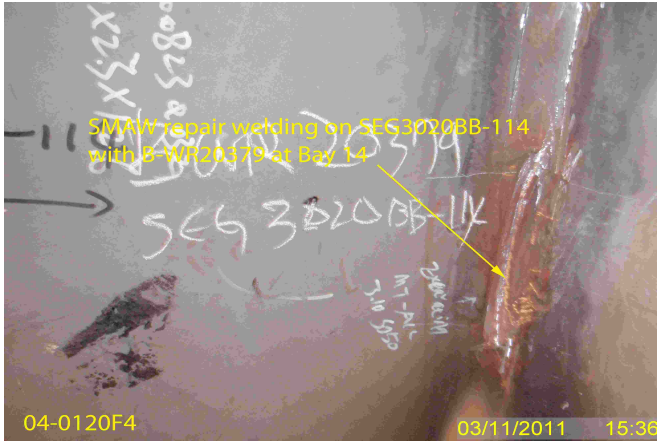
Components: 13AW
PCMK: SEG3012-004
Welder: 045265
WPS-B-T-2221-B-U2-S-1

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; Anchor Plate Bearing Block on NWIT tracker document # 08519 and 08520,

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
